June 22, 2010 2:31:53 PM

Item ID:

D4051-1

Accept

Setup

Start

Stop



**Revision ID:** 

Item Name:

Rappel Deflector

**Start Date:** 

6/22/10

Start Qty: 2.00

Req'd Qty: 2.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Date: 10-6-22 Tooling:

Run

Start

Stop



Required Date: 6/29/10

Date:

SPC (Y/N):

Date:

Reject Accept

Insp. Reject

Sequence ID/ **Work Center ID**  Operation Description

**Revision Nbr** 

Set Up/ **Run Hours**  Tool ID Tool # Plan

**Qty** Code

**Qty** 

Number Stamp

Draw Nbr D4051

0.00

Large Fab Large Fab

100

Memo

0.00

1- Cut tube 50" and remove identification markings

2- Bend tube with manuel pipe bender as per template DT9574 (Make first line

at 1.00")

3- Trim access tube material to finish size as per dwg D4051

SAO 10-06-28

110

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Packaging

Identify as per dwg & Stock Location

0.00

10.10.01 Of @

Memo

Packaging

### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval Approval QC Inspector DATE **STEP** PROCEDURE CHANGE By Qty Chief Eng / Prod Mgr Date Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Date: \_\_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Sign & Initial **Action Description** Section A Section C QC Inspector Chief Eng Chief Eng Date Chief Eng

| June 22, 2010 2:31:53 PM | Work | Ord  | ler | ID     | 59 | 998 |
|--------------------------|------|------|-----|--------|----|-----|
|                          | ,    | 2010 | 2:3 | 1:53 F | PM |     |



Page 2

| June 22, 2010 2                | 2:31:53 PM  |                          |                      |                      | - 1-11- 1-121 1-11 1 <b>-1</b> 1 |        | 1            |               |             |       |                  |  |      |
|--------------------------------|-------------|--------------------------|----------------------|----------------------|----------------------------------|--------|--------------|---------------|-------------|-------|------------------|--|------|
| Item ID:                       | D4051-1     |                          |                      | Accept               |                                  |        |              | IIII s        | Setup       | Start |                  |  |      |
| Revision ID:                   |             |                          |                      |                      |                                  |        | ,;<br>,;     | ==11 /==1     |             |       |                  | 1816 110 1161 100<br>1816 110 1161 100 | <br> |
| Item Name:                     | Rappel Defl | ector                    |                      |                      |                                  |        | j:<br>I:     |               |             | Stop  |                  |  | il   |
| Start Date:                    | 6/22/10     | Start Qty: 2.00          |                      |                      | Cust Item                        | ID:    | Í            |               |             |       | 1 (5511)91 9     | 18,18 118 1181 188                     | •    |
| Required Date:                 | 6/29/10     | Req'd Qty: 2.00          |                      |                      | Customer                         | :      | -            |               |             |       |                  |  |      |
| Reference:                     |             |                          | 118818 118118        |                      |                                  |        |              |               |             |       |                  |  |      |
| Approvals:                     | Process P   | lan:                     | Date:                | Tooling:             |                                  | Date:  |              | F             | Run         | Start |                  |  |      |
|                                | QC:         |                          | Date:                | SPC (Y/N):           | I                                | Date:  |              |               |             | Stop  |                  |  |      |
| Sequence ID/<br>Work Center II | <b>D</b>    | Operation<br>Description |                      | Set Up/<br>Run Hours | Tool ID                          | Tool # | Plan<br>Code | Accept<br>Qty | Reje<br>Qty |       | Reject<br>Number | Insp.<br>Stamp                         |      |
| 130                            |             | QC21- Final Inspection   | - Work Order Release | 0.00                 |                                  | •      |              | - •           | - •         |       | 10/00            | 1/21                                   | \$   |
| QC                             |             | Memo                     |                      | 0.00                 |                                  |        | ļ            |               |             | +     | vv-              | 1112 , =                               | (    |
| Quality Control                |             |                          |                      |                      |                                  |        |              |               |             |       | 1                |  |      |

MF 10-7-01

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

| Part No:    | _ PAR #: | Fault Category: | NCR: Yes No   | DQA: | <br>Date: |
|-------------|----------|-----------------|---------------|------|-----------|
| Resolution: |          | Disposition:    | QA: N/C Close | d:   | <br>Date: |

Approval QC Inspector

| NCR:  |      |   | WORK ORDE  | R NON-CONFORMAN | CE (NCR)     |                       |                          |   |
|-------|------|---|--|-----------------|--------------|-----------------------|--------------------------|---|
| 5.477 |      | Description of NC Corrective Action Section B |  |                 | Verification |                       |                          |   |
| DATE  | STEP | Section A                                     | Initial Action Description Sign & Chief Eng Chief Eng Date |                 | Section C    | Approval<br>Chief Eng | Approval<br>QC Inspector |   |
|       |      |   |  |                 |              | ÷                     |                          |   |
|       |      |   |  |                 |              |                       |                          |   |
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|       |      |   |  |                 |              |                       |                          |   |

### **Picklist Print**

June 22, 2010 2:31:52 PM

Work Order ID: 59998

Parent Item:

D4051-1

Parent Item Name: Rappel Deflector



WA

114724

**Start Date:** 6/22/10

Start Qty: 2.00

Required Date: 6/29/10

Page 1

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 10.01.12 verified by:EC

REV.A DD 10.02.22 verified by:EC

IPP Rev:B as per dwg

| Component Item ID/<br>Item Name | Replacement<br>Item ID   | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit |          | Qty<br>Issued | Date<br>Issued                        | Status     |
|---------------------------------|--------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|----------|---------------|---------------------------------------|------------|
| M304TS0.500W.049                | NE 118101 BIZZ BEZZ BEZZ | Purchased     | No          |                     |                  | 100             | f                  | 155.2554       | 4.1666      | 8.771789 |               | · · · · · · · · · · · · · · · · · · · | F          |
|                                 |                          |               |             |                     |                  |                 |                    |                |             | 900      | 100-0         |                                       | <b>⊃</b> ঐ |

Square Tubing

| <b>Location</b> | Loc Qty     | Loc Code |
|-----------------|-------------|----------|
| MAT             | 148.1591158 |          |
| 114004          | 0           |          |
| 114426          | 9.2647      |          |
| 114807          | 138.894416  |          |
| MAT018          | 4.4738      |          |
| 114004          | 0.5         |          |
| 114161          | 3.9738      |          |

2.62251

2.62251

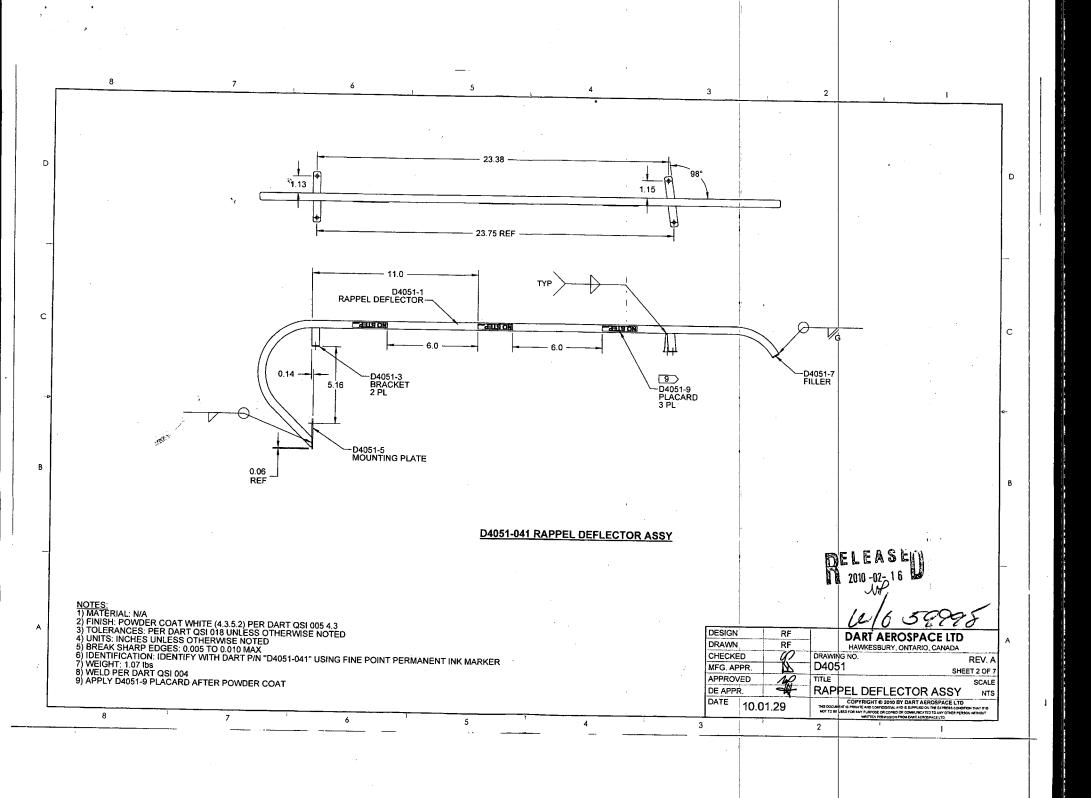
8.771789

### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval Chief Eng / **Approval** DATE STEP **PROCEDURE CHANGE** Ву Date **D**ty QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Date: \_\_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Initial **Action Description** Sign & Section A QC Inspector Section C Chief Eng Chief Eng Chief Eng Date

QTY -041 ITÉM DESCRIPTION SHOP COPY X D4051-041 RAPPEL DEFLECTOR ASSY RETURN TO RAPPEL DEFLECTOR ASSY D4051-042 ENGINEERING D4051-1 RAPPEL DEFLECTOR UNCONTROLLED CO D4051-3 .2 2 BRACKET D SUBJECT TO AMENDMEN 3 1 D4051-7 FILLER 4 D4051-5 MOUNTING PLATE WITHOUT NOTICE WORK OR 3 998 210-6-22 5 D4051-9 3 PLACARD D4051-041 RAPPEL DEFLECTOR ASSY (SHOWN) D4051-042 RAPPEL DEFLECTOR ASSY (OPPOSITE) NEW ISSUE Α 10.01.29 REV. DESCRIPTION BY DATE DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4051 MFG. APPR. SHEET 1 OF 7 APPROVED TITLE SCALE RAPPEL DEFLECTOR ASSY DE APPR COPYRIGHT @ 2010 BY DART AEROSPACE LTD DATE 10.01.29

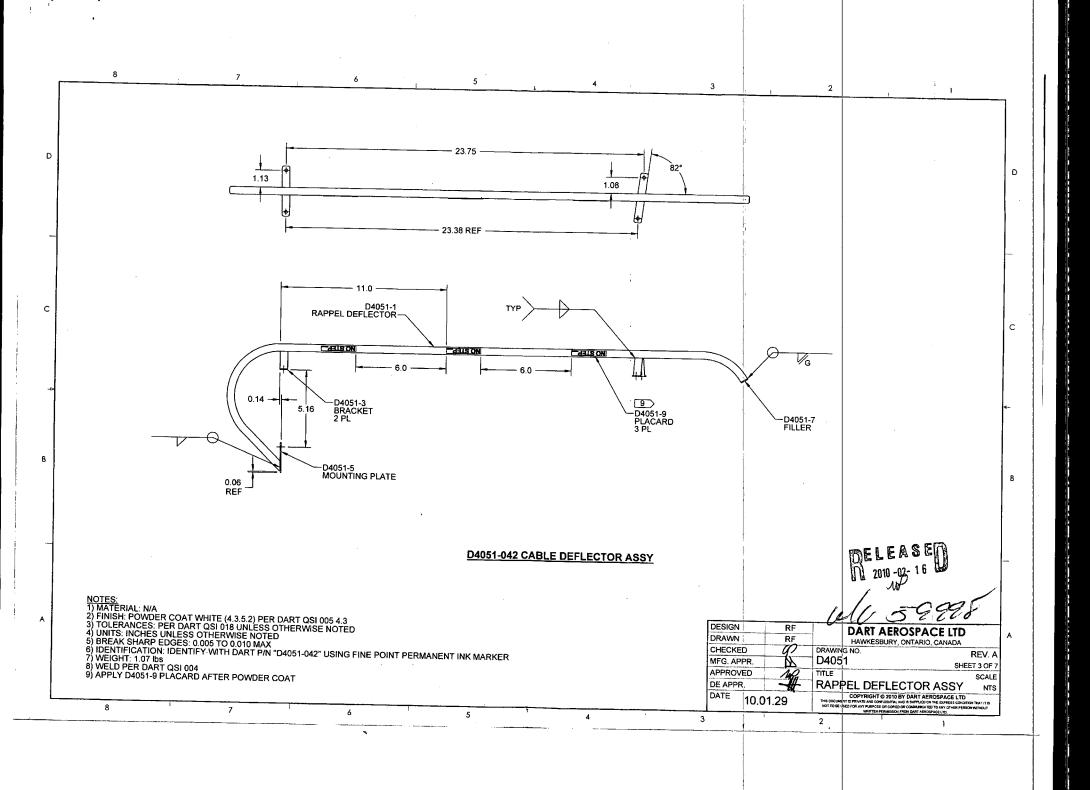
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| W/O:    |      |                   | V          | VORK ORDER CHANG                             | iES   |         |                 |     |                               | •                        |
|---------|------|-------------------|------------|--|-------|---------|-----------------|-----|-------------------------------|--------------------------|
| DATE    | STEP | PRO               | OCEDURE CH | IANGE  |       | Ву      | Date            | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
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| Part No | :    | PAR #:            | Fault Ca   | tegory:                                      | _ NCR | : Yes N | lo <b>DQA</b> : |     | Date:                         |                          |
|         | R    | esolution:        | Disposit   | ion:   | _ QA: | N/C Clo | sed:            |     | Date:                         |                          |
| NCR:    |      |                   | WORK OR    | DER NON-CONFORM                              | ANCE  | (NCR)   |                 |     |                               |                          |
| DATE    | STEP | Description of NC | Initial    | Corrective Action Section Action Description | ion B | Sign &  | Verifica        |     | Approval                      | Approval                 |
|         |      | Section A         | Chief Eng  | Chief Eng                                    |       | Date    | Section         | C   | Chief Eng                     | QC Inspector             |
|         |      |                   |            |  | i.    |         |                 |     |                               |                          |
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| Dart Aerospace Ltd | Dart | <b>Aeros</b> | pace | Ltd |
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| W/O:        |                 |                   |                      | 1                            |             |                 |      |                                     |                                       |
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| DATE        | STEP            | PRO               | CEDURE CH            | ANGE                         | Ву          | Date            | Qty  | Approval<br>Chief Eng /<br>Prod Mgr | Approval QC Inspector                 |
|             |                 |                   |                      |                              |             |                 |      | Prod Wigi                           | · · · · · · · · · · · · · · · · · · · |
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| 775h-1      |                 |                   |                      |                              |             |                 |      |                                     |                                       |
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| Part No     | Part No: PAR #: |                   | Fault Cat            | egory:                       | _ NCR: Yes  | No <b>DQA</b>   |      | _ Date: _                           |                                       |
| Resolution: |                 |                   | Dispositi            | on:                          | _ QA: N/C C | losed:          |      | Date:                               |                                       |
| NCR:        |                 | V                 | VORK ORI             | DER NON-CONFORMA             | NCE (NCI    | ₹)              |      |                                     |                                       |
| D.4.T.F.    | OTED            | Description of NC |                      | Corrective Action Secti      |             | Verifica        | tion | Approval                            | Approval                              |
| DATE        | STEP            | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign Date   | Section Section |      | Chief Eng                           | QC Inspector                          |
|             |                 |                   |                      |                              |             |                 |      |                                     |                                       |
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| W/O:    |      |   | WORK ORDER CHANGES |                 |         |                |                    |     |                               |                          |
|---------|------|---|--------------------|-----------------|---------|----------------|--------------------|-----|-------------------------------|--------------------------|
| DATE    | STEP | PRO   | OCEDURE CH         | ANGE            |         | Ву             | Date               | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |      |   |                    |                 |         |                |                    |     |                               |                          |
|         |      |   |                    |                 |         |                | 5 d d d            |     |                               |                          |
|         |      |   |                    |                 |         |                |                    |     |                               |                          |
| Part No | :    | PAR #:  | Fault Ca           | tegory:         | NCR     | : Yes I        | No <b>DQA</b>      |     | Date:                         |                          |
|         | R    |   |                    | Disposition:    |         |                |                    |     | Date:                         |                          |
| NCR:    |      | ,   | WORK OR            | DER NON-CONFORM | IANCE   | (NCR)          | )                  |     |                               |                          |
| DATE    | STEP | Description of NC Section A  Corrective Action Section Initial Action Description Chief Eng Chief Eng |                    |                 | ction B | Sign &<br>Date | Verific<br>Section |     | Approval<br>Chief Eng         | Approval<br>QC Inspector |
|         |      |   | 3                  |                 |         |                |                    |     | -                             |                          |
|         |      |   |                    |                 |         |                |                    |     |                               |                          |
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|         |      |   |                    |                 |         |                |                    |     |                               |                          |

D: 135°±15° CLR3.25 8.53 8 D4051-1 RAPPEL DEFLECTOR NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.98 lbs
8) TUBE FLAT LENGTH 43.00 REF DESIGN RF **DART AEROSPACE LTD** DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4051 MFG. APPR SHEET 4 OF 7 APPROVED TITLE RAPPEL DEFLECTOR ASSY

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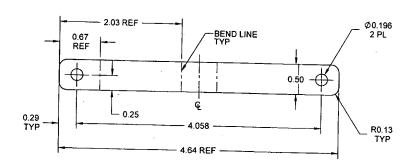
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| W/O:        |      |                   |                      |                              |           |                |            |      |                               |                          |
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| DATE        | STEP | PRO               | OCEDURE CH           | ANGE                         |           | Ву             | Date       | Qty  | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|             |      |                   |                      |                              |           |                |            |      |                               |                          |
|             |      |                   |                      |                              |           |                |            |      |                               |                          |
|             |      |                   |                      |                              |           |                |            |      |                               |                          |
| Part No     |      | PAR #:            | Fault Ca             | tegory:                      | NC        | R: Yes         | No DQA     |      | Date:                         |                          |
| Resolution: |      |                   | Disposit             | ion:                         | QA        | : N/C CI       | osed:      |      | Date:                         |                          |
| NCR:        |      | ,                 | WORK OR              | DER NON-CONFO                | RMANCI    | E (NCF         | <b>(1)</b> |      |                               |                          |
| DATE        | STEP | Description of NC |                      | Corrective Action            | Section B |                | Verifica   | tion | Approval                      | Approval                 |
| DAIL        | SIEF | Section A         | Initial<br>Chief Eng | Action Descript<br>Chief Eng | ion       | Sign 8<br>Date | Sectio     | С    | Chief Eng                     | QC Inspector             |
|             |      |                   |                      |                              |           |                |            |      |                               |                          |
|             |      |                   |                      |                              |           |                |            |      |                               |                          |
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0.63 - 1.35 --R0.13 4 PL 1.24 0.060 REF 0.69 TYP 3.33 REF

D4051-3 BRACKET (MAKE FROM D4051-3F FLAT PATTERN)



### **D4051-3F FLAT PATTERN**

NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs

DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A D4051 SHEET 5 OF 7 TITLE SCALE

10.01.29

RAPPEL DEFLECTOR ASSY

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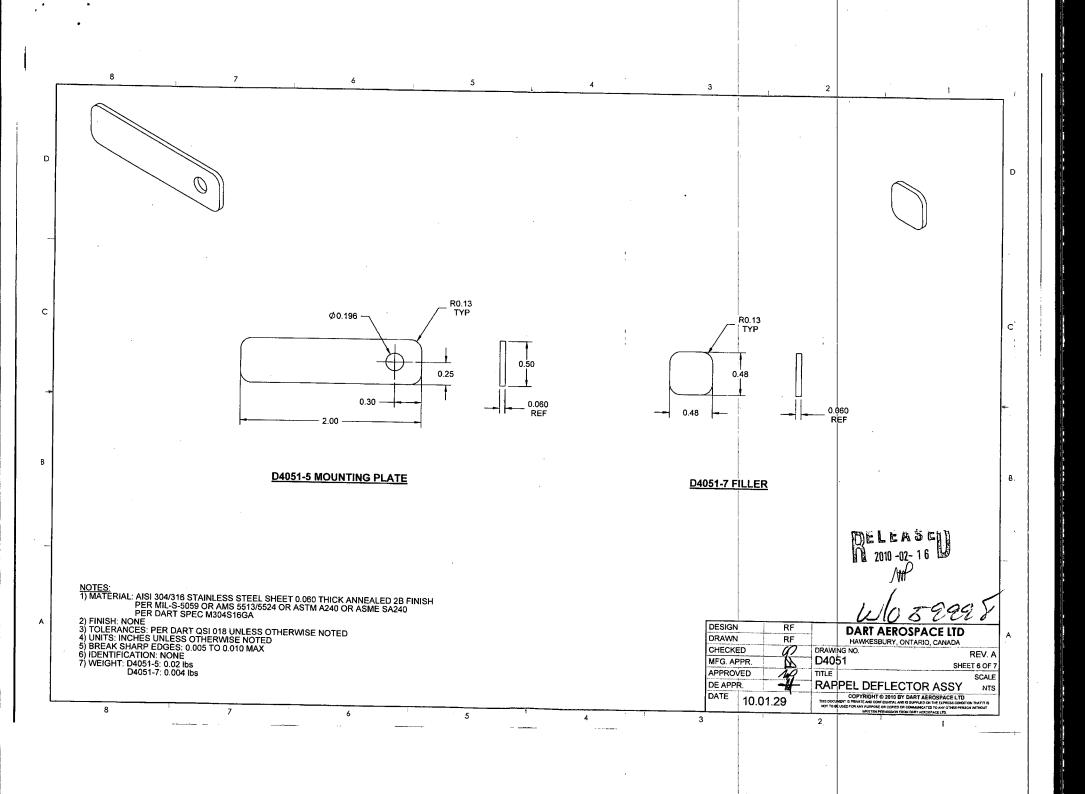
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| W/O:        |                        |           | V                    | VORK ORDER CHANG              | ES          |       |         |                               |                          |
|-------------|------------------------|-----------|----------------------|-------------------------------|-------------|-------|---------|-------------------------------|--------------------------|
| DATE        | STEP                   | PRO       | OCEDURE CH           | IANGE                         | Ву          | Date  | Qty     | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|             |                        |           |                      |                               |             |       |         |                               |                          |
|             |                        |           |                      |                               |             |       |         |                               |                          |
|             |                        |           |                      |                               |             |       |         |                               |                          |
|             |                        |           |                      |                               |             |       |         |                               |                          |
| Part No     | ):                     | PAR #:    | Fault Ca             | tegory:                       | _ NCR: Yes  | No DC | PA      | Date:                         |                          |
| Resolution: |                        |           | <u> </u>             |                               |             |       |         | Date: _                       |                          |
| NCR:        |                        | ,         | WORK OR              | DER NON-CONFORMA              | ANCE (NC    | R)    |         |                               |                          |
| DATE        | STEP Description of NC |           |                      | Corrective Action Secti       |             | Verif | ication | Approval                      | Approval                 |
| DAIL        | SILF                   | Section A | Initial<br>Chief Eng | Action Description  Chief Eng | Sign<br>Dat | e Sec | tion C  | Chief Eng                     | QC Inspector             |
|             | 1                      |           |                      |                               |             |       |         |                               | <u> </u>                 |
|             |                        |           |                      |                               |             |       |         |                               |                          |
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| W/O:      |      | WORK ORDER CHANGES                 |                          |                              |         |                |                 |           |                               |                          |  |
|-----------|------|------------------------------------|--------------------------|------------------------------|---------|----------------|-----------------|-----------|-------------------------------|--------------------------|--|
| DATE STEP |      | PROCEDURE CHANGE                   |                          |                              |         | Ву             | Date Qty        | Qty       | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |
|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |
|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |
|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |
|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |
| Part No:  |      | PAR #:                             | Fault Category: NCR: Yes |                              |         | Yes N          | lo <b>DQA</b> : |           | _ Date: _                     |                          |  |
|           | Re   | esolution:                         | Disposition              | on:                          | QA: I   | V/C Clo        | sed:            | -         | Date:                         |                          |  |
| NCR:      |      | •                                  | WORK ORE                 | DER NON-CONFORM              | IANCE   | (NCR)          |                 |           |                               |                          |  |
| DATE      | STEP | <b>Description of NC</b> Section A |                          |                              | ction B | Verifical      |                 | tion      | Approval                      | Approval                 |  |
|           |      |                                    | Initial<br>Chief Eng     | Action Description Chief Eng |         | Sign &<br>Date | Section         |           | Chief Eng                     | QC Inspector             |  |
|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |
|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |
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|           |      |                                    |                          |                              |         |                |                 |           |                               |                          |  |

8 2 P/N D4051-9 0.05 D4051-9 PLACARD В NOTES:
1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: N/A DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. D4051 MFG. APPR. SHEET 7 OF 7 APPROVED TITLE SCALE RAPPEL DEFLECTOR ASSY

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# **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: **Approval Approval** STEP **PROCEDURE CHANGE** Qty DATE By Date Chief Eng / QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ QA: N/C Closed: \_\_\_ \_\_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR)

| NCR: |      | VV                             |                             |                              |                |              |           |              |
|------|------|--------------------------------|-----------------------------|------------------------------|----------------|--------------|-----------|--------------|
| DATE | STEP | Description of NC<br>Section A | Corrective Action Section B |                              |                | Verification | Approval  | Approval     |
|      |      |                                | Initial<br>Chief Eng        | Action Description Chief Eng | Sign &<br>Date | Section C    | Chief Eng | QC Inspector |
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